

Date: Tuesday, 19/08/2008 10:44:01 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 41385 - 5-4	Part Number	: D37695
Estimate Number	: 13374	Drawing Number	: D3769 REVA
P.O. Number	:	Project Number	: N/A
This Issue	: 19/08/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : SMALL /MED FAB	Due Date	: 20/08/2008
Previous Run	: 40977	Qty:	20 Um: Each
Written By	:		
Checked & Approved By	: <u>mf 08-08-19</u>		
Comment	: Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W065

6061T6 RD TUBE 1.00 x .065w



Comment: Qty.: 1.7579 f(s)/Unit Total: 35.1582 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch: M109000

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3769

2-drill holes thru on both ends of tube as per dwg D3769

3- deburr

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

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Seq. #:

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Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/08/27 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



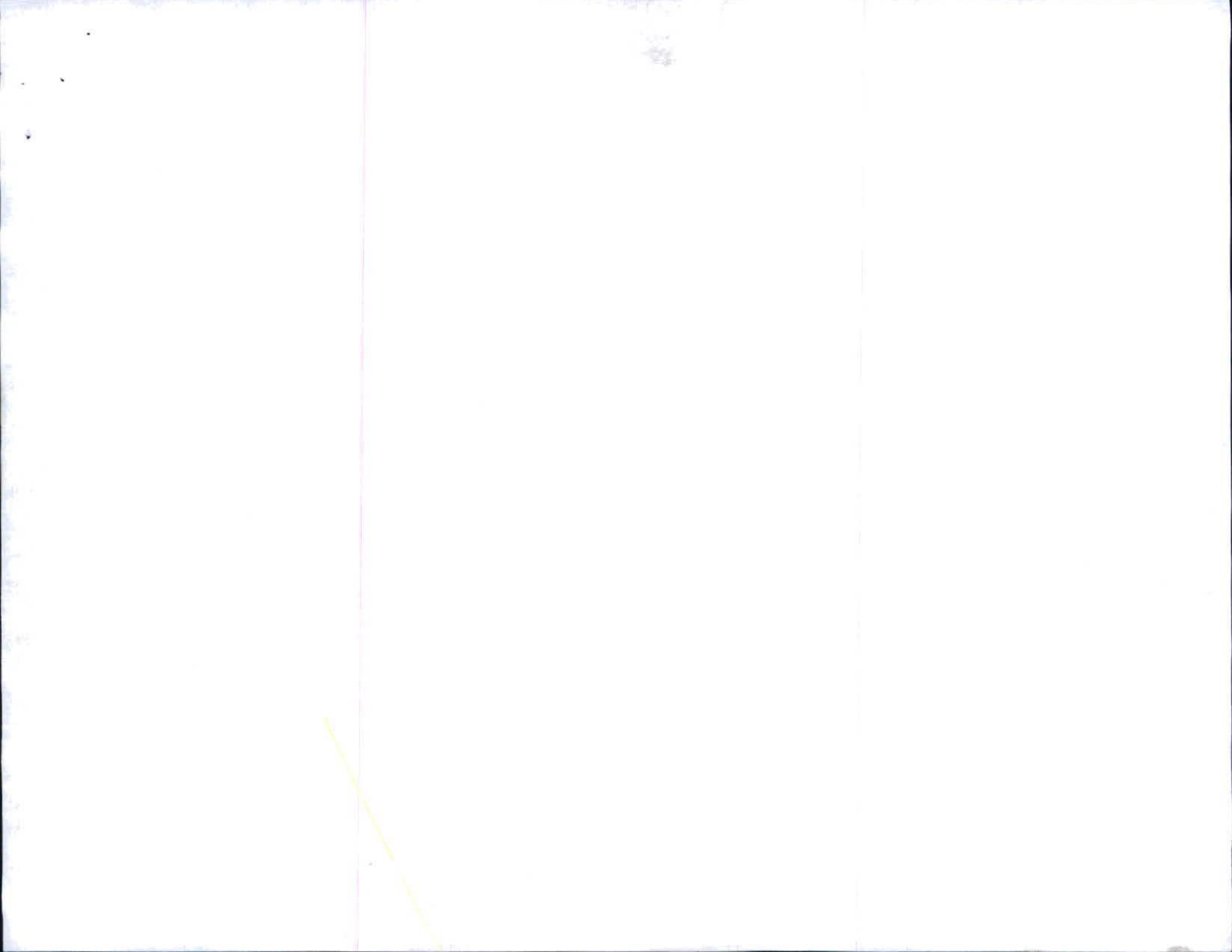
Comment: FINAL INSPECTION/W/O RELEASE

08/08/27 HJ

Job Completion



MF 08-08-27



8 7 6 5 4 3 2 1

D

D

C

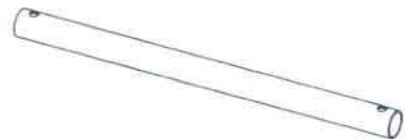
C

B

B

A

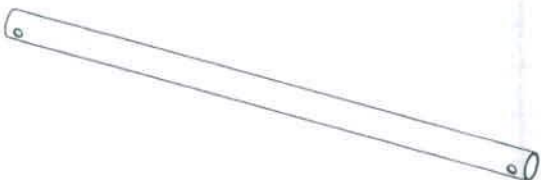
A



D3769-1 TUBE



D3769-3 TUBE



D3769-5 TUBE

41385

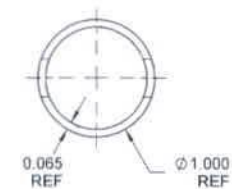
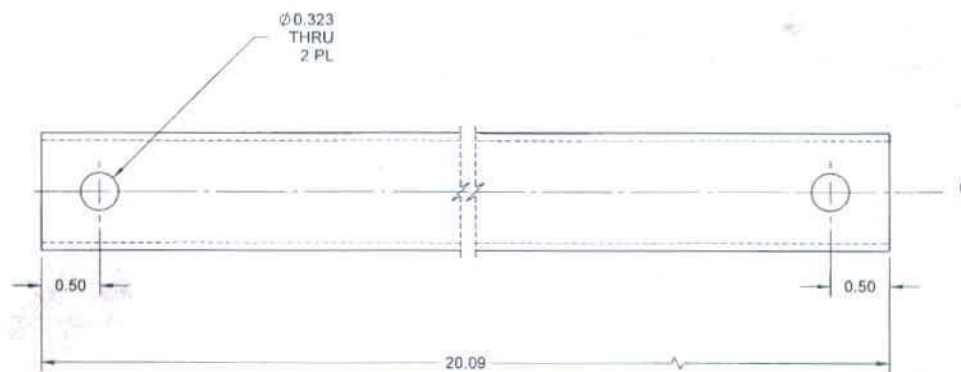
RELEASED
08 06 14

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	HS	D3769	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	TUBE	NTS
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8 7 6 5 4 3 2 1



W/O 41385

D3769-5 TUBE

RELEASED
CR-D-16-107

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR	<i>[Signature]</i>	D3769	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	TUBE	NTS
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